

Date Wednesday, 15/08/2007 4:07:20 PM
 User Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HINGE BRACKET |
| Job Number | : 33968 | Part Number | : D35381 |
| Estimate Number | : 12543 | Drawing Number | : D3538 REV.A |
| P.C. Number | : N/A | Project Number | : 10254N/A |
| This Issue | : 15/08/2007 S.O. No. : N/A | Drawing Revision | : A |
| Prsh Rev. | : NC | Material | : N/A |
| First Issue | : N/A | Due Date | : 31/08/2007 Qty: 20 Um: Each |
| Previous Run | : 32371 | Type | : MACHINED PARTS |
| Written By | : <u>J.F. 07-08-016</u> | | |
| Checked & Approved By | | | |
| Comment | : Est Rev:A New Issue 06-10.03 EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--------------------|
| 1.0 | M6061T6B1250X01250 | 6061-T6 Bar 1.25 x 1.25" | |
| | | Comment: Qty.: 0.1995 f(s)/Unit Total: 3.9900 f(s) 6061_T6 Bar 1.250" x 1.250 Batch: M 104554 | J.F. 07/08/25 (20) |
| 2.0 | BAND SAW | BAND SAW | |
| | | Comment: BAND SAW Cut blanks 1.500" long | J.F. 07/08/25 (20) |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: 1-Machine as per Folio FA651 and Dwg D3538 | |
| | 2-Deburr | | J.F. 07/08/26 (20) |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | J.F. 07/08/26 (20) |
| 5.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | J.F. 07/08/26 (20) |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/30
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:07:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33968

Part Number: D35381

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15 07.08.27 20

7.0 POWDER COATING

POWDER COATING



M105068

QCR

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.f 07/08/28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ep 07/08/29 29 W

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

108

107/08/29 29 W

29

10.0 QC21

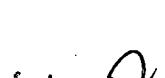
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/08/30

Job Completion



107/08/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

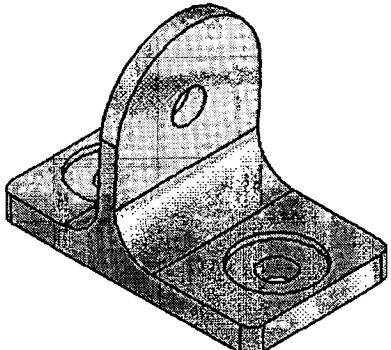
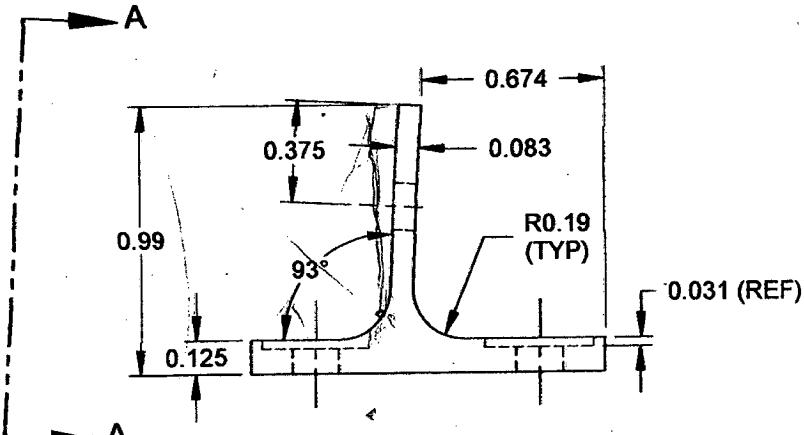
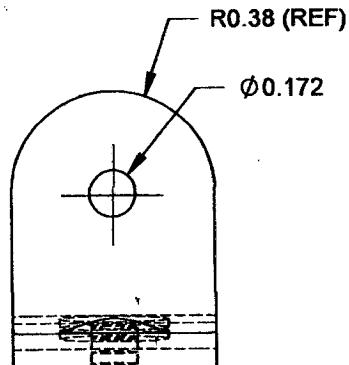
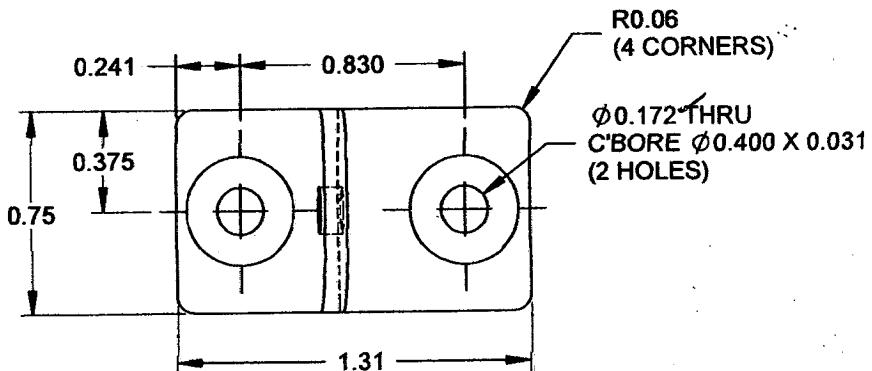
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>CE</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>#</i> | DRAWING NO. D3538 | REV. A SHEET 1 OF 2 |
| DATE 06.10.13 | | TITLE HINGE BRACKET | SCALE 1:1 |
| REV A | DATE 06.10.13 | DESCRIPTION NEW ISSUE | |

**RELEASED**
06.10.13 #**D3538-1 HINGE BRACKET****NOTES:**

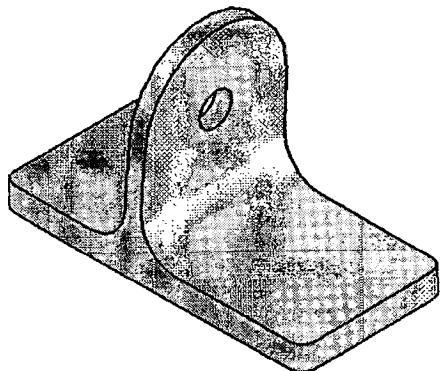
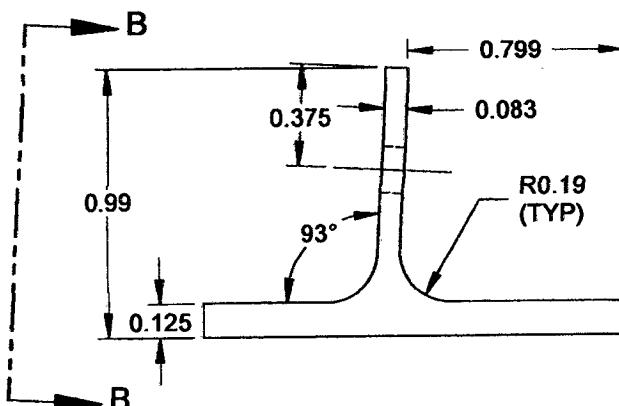
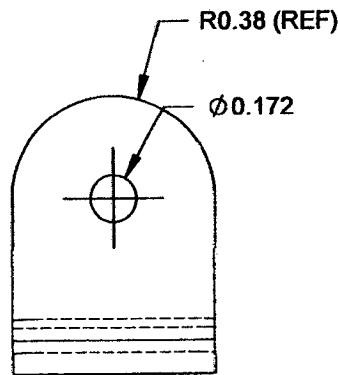
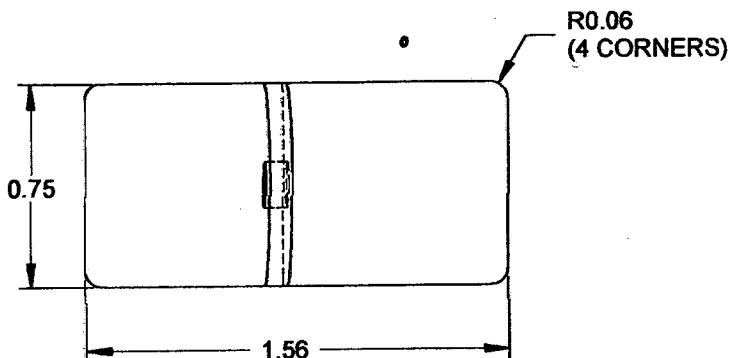
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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DART

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|----------------------|------------------------|---|------------------------|
| DESIGN <i>CE</i> | DRAWN BY <i>CE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>#</i> | DRAWING NO. D3538 | REV. A SHEET 2 OF 2 |
| DATE 06.10.13 | TITLE HINGE BRACKET | SCALE 1:1 | |

**RELEASED**
06.10.13 *#***AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33968 |
| Description: Hinge Bracket | Part Number: | D3538-1 |
| Inspection Dwg: D3538 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|--|
| Measured by: | J.F. | Audited by: | J.F. | Prototype Approval: | |
| Date: | 07/08/25 | Date: | 07/08/26 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |